

Thursday, 5/10/2007 2:25:36 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206 A/B HIGH GEAR WEB	
Job Number	32279		Part Number	D26543	
Estimate Number	10455		Drawing Number	D2654 REV E1	
P.O. Number	N/A		Project Number	N/A	
This Issue	5/10/2007		Drawing Revision	E1	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	5/17/2007	
Previous Run	30724		Qty:	4	Um: Each
Written By					
Checked & Approved By	5/10/07.05.10				
Comment	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D26005108	Extrusion 'I Beam' thin			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web 329985 (3) JB 7-5-14					
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1			
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends (3) JB 7-5-14					
3.0	QC5	INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP (3) JB 7-5-23					
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 (3) JB 7-5-13					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ○ No ○ DQA: JD Date: 07/05/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
0705-23	2.0	1 web scrap. was cut • 450" too short. Human error.	<u>Q</u> QSL042	destroy web & replace. Ensure the length is to 450" before cutting. Measure twice, cut once.		JD 7-5-23	<u>Q</u> QSL042	<u>Q</u> QSL042	<u>Q</u> 0705-23

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:25:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 32279

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JP

7-5-23

④

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG

JP 7-5-23 ④

7.0 QC21

FINAL INSPECTION/W/O RELEASE



④

Comment: FINAL INSPECTION/W/O RELEASE

19 07/05/04

Job Completion



19 07/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

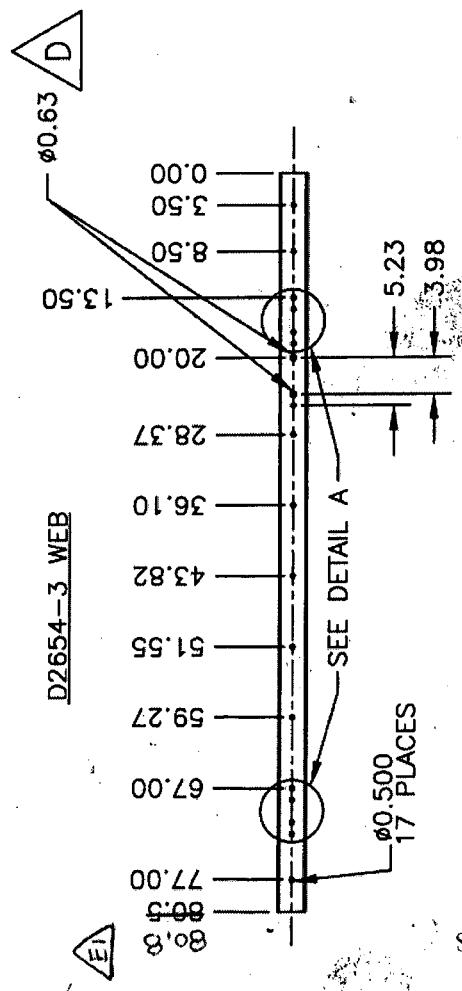
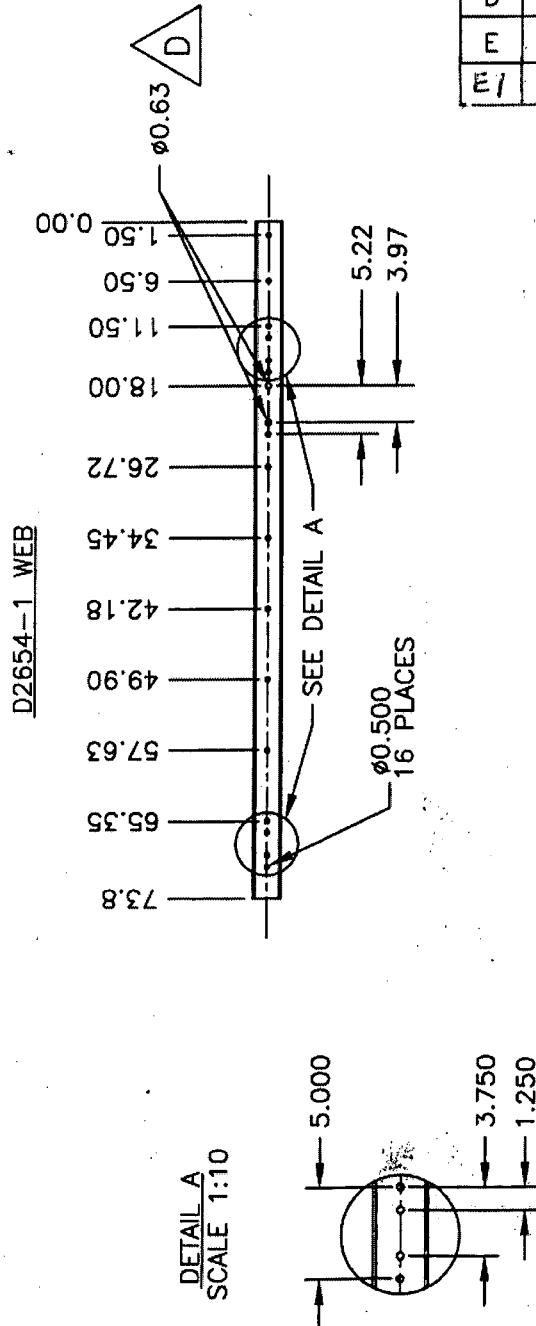
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

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MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

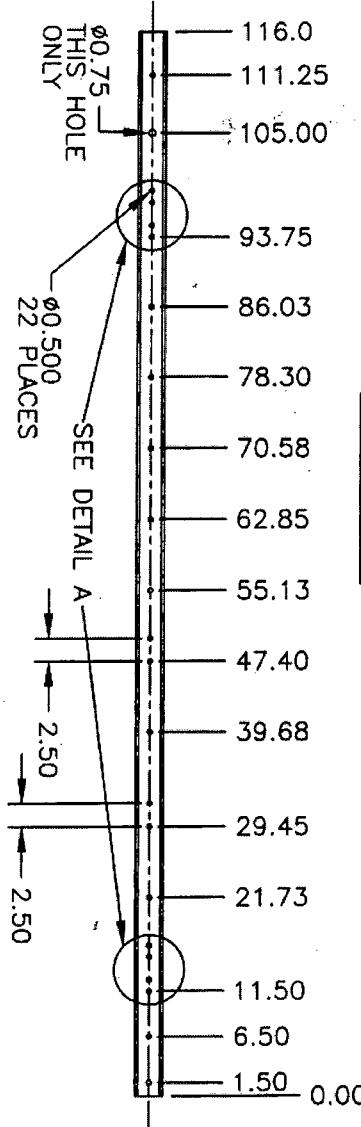
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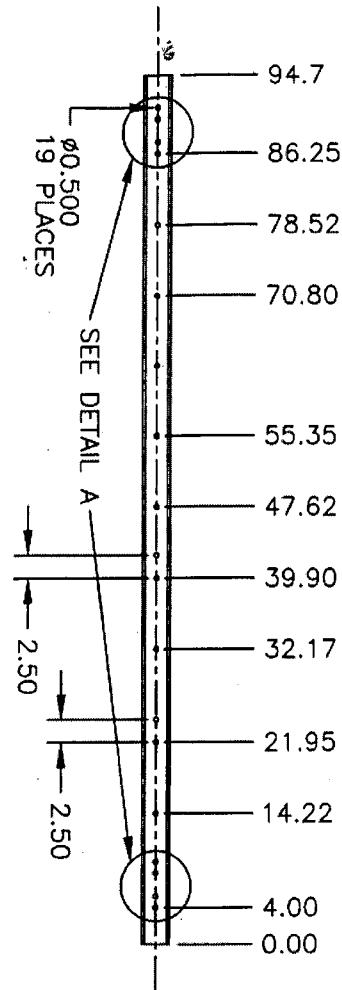
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MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2654-7 WEB



DETAIL A
SCALE 1:10

RELEASED 04/22/97

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DART

